

ALLROUNDER 270 A

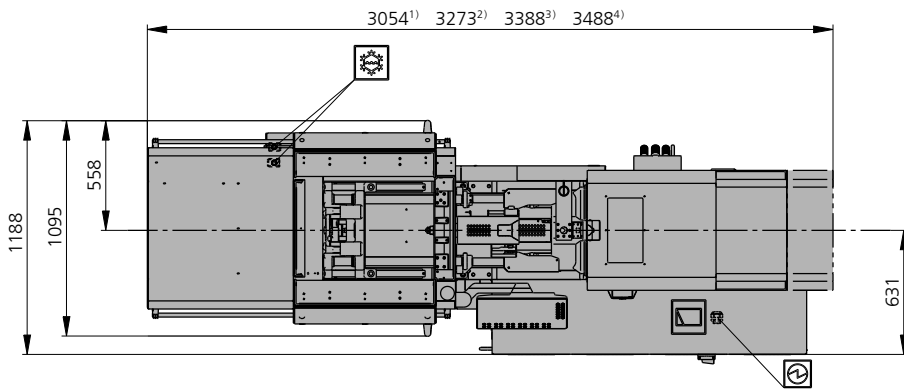
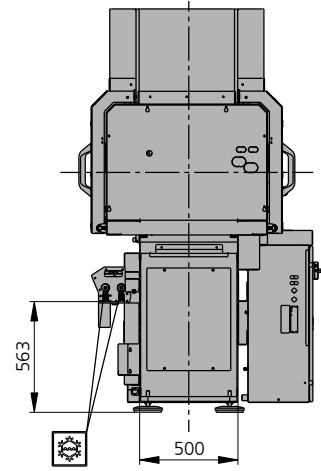
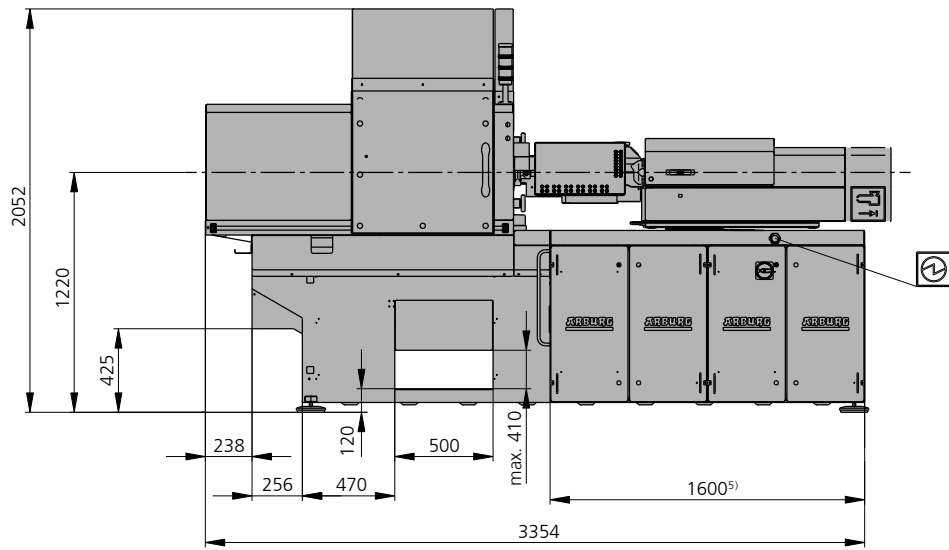
Distance between tie bars: 270 x 270 mm

Clamping force: 350 kN

Injection unit (acc. to EUROMAP): 5, 70, 100

ARBURG

MACHINE DIMENSIONS | 270 A



Electrical connection



Cooling water connection

- 1) Injection unit 5
- 2) Injection unit 70
- 3) Injection unit 100 Comfort
- 4) Injection unit 100 Premium/Ultimate
- 5) Depending on the performance and size of the injection unit

TECHNICAL DATA | 270 A

Clamping unit			270 A		
with clamping force	max. kN		350		
Opening force stroke	max. kN mm		--- 200		
Mould height, fixed variable	min.-max. mm		--- 150-350		
Platen daylight fixed variable	max. mm		--- 350-550		
Distance between tie bars (w x h)	mm		270 x 270		
Mould mounting platens (w x h)	max. mm		380 x 380		
Weight of movable mould half	max. kg		200		
Ejector force stroke	max. kN mm		16 60		
Dry cycle time EUROMAP	Comfort	min. s - mm	1 - 189		
	Premium	min. s - mm	0,9 - 189		
	Ultimate	min. s - mm	0,7 - 189		

Injection unit			5		70			100		
with screw diameter	mm		8		18	22	25	20	25	30
Effective screw length	L/D		12		24,5	20	17,5	25	20	16,7
Screw stroke	max. mm		50		90			100		
Calculated stroke volume	max. cm ³		2,5		23	34	44	31	49	71
Shot weight	max. g PS		2,3		21	31	40	29	45	65
Material throughput	max. kg/h PS		1		4,1	5,5	6,5	5,5	8	9,5
	max. kg/h PA6.6		0,5		2,1	2,8	3,3	2,8	4	4,9
Injection pressure	max. bar		2000		2500	2000	1550	2500	2000	1390
Holding pressure time	max. s - bar		300-1600		300-2390	300-1600	300-1240	300-2500	300-1600	300-1110
Injection flow ²	Comfort [+]	max. cm ³ /s	---		51 [66]	76 [99]	98 [127]	64 [83]	100 [130]	144 [187]
	Premium	max. cm ³ /s	---		66	99	127	83	130	187
	Ultimate [+]	max. cm ³ /s	25		76 [101]	114 [152]	147 [196]	94 [125]	148 [197]	214 [285]
Injection speed ⁵	Comfort [+]	max. mm/s	---		280 [350]			280 [350]		
	Premium	max. mm/s	---		350			350		
	Ultimate [+]	max. mm/s	500		350 [400]			350 [400]		
Screw circumferential speed	max. m/min		9		45	55	63	40	50	60
Screw torque	max. Nm		12		90	110	120	120	150	180
Nozzle contact force retraction stroke	max. kN mm		5 150		50 230			50 230		
Heating capacity zones	kW		1,5 5		4,2 4			6,7 5		
Feed hopper	l		1,8		25			50		

Drive and connection			Comfort		Premium		Ultimate		
with injection unit			70	100	70	100	5	70	100
Net weight of machine	kg		2350	2490	2350	2490	2300	2350	2490
Sound press. level Insecurity ⁴	dB(A)		63 3		63 3		63 3		
Electrical connection ³		kW	11	13	11	13	13	16	18
	Total	A	40	50	40	50	50	50	63
	Machine	A	---		---		---		
	Heating	A	---		---		---		
Cooling water connection	max. °C		30		30		30		
	min. Δp bar		1,5 DN 25		1,5 DN 25		1,5 DN 25		

Machine type

with EUROMAP size designation ¹

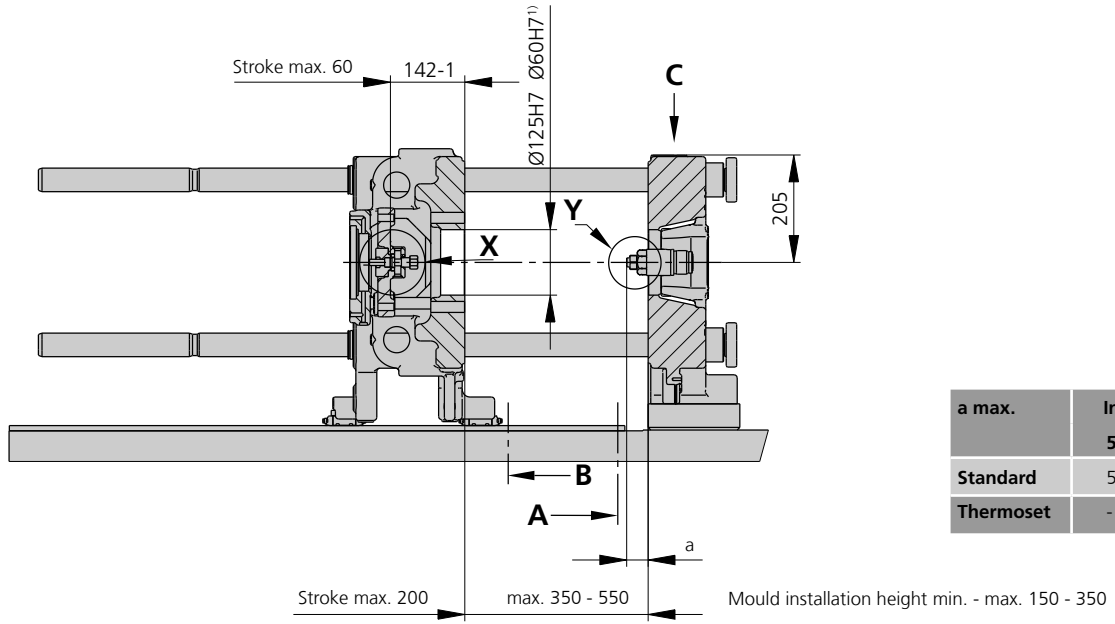
270 A 350-5
270 A 350-70 | 100

Upon request: other machine types and mould installation heights, screws, drive powers etc.

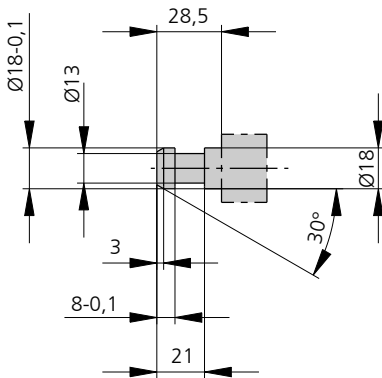
All specifications relate to the basic machine version. Deviations are possible depending on variants, process settings and material type. Depending on the drive, certain combinations, e.g. max. injection pressure and max. injection flow may be mutually exclusive.

- 1) Clamping force (kN) - size of injection unit = max. stroke volume (cm³) x max. injection pressure (kbar)
 - 2) Specification of maximum injection flow at maximum injection pressure.
 - 3) Specifications relate to 400 V/50 Hz.
 - 4) Emission sound pressure level at the workplace. Detailed information in the operating instructions.
 - 5) Forward speed of plasticising screw at 1000 bar injection pressure.
- [] Specifications apply to alternative equipment.

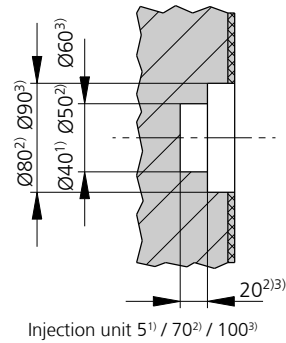
MOULD INSTALLATION DIMENSIONS | 270 A



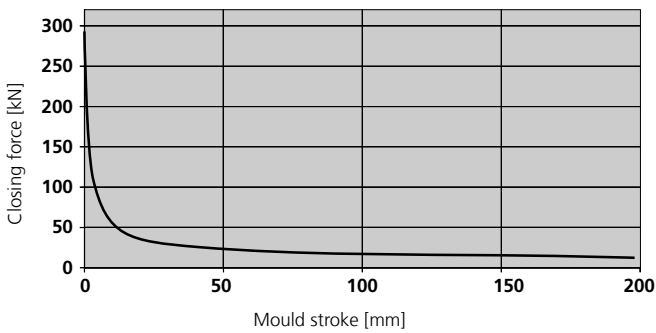
Ejector bolt | X



Bore in mould (if required) | Y

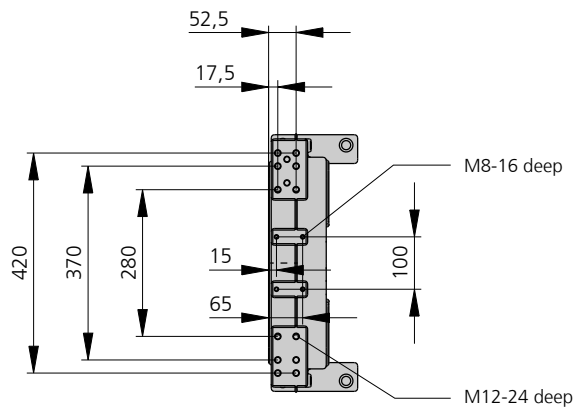


Closing force for spring moulds / during injection compression moulding*



* automatic locking force adjustment up to 20 kN

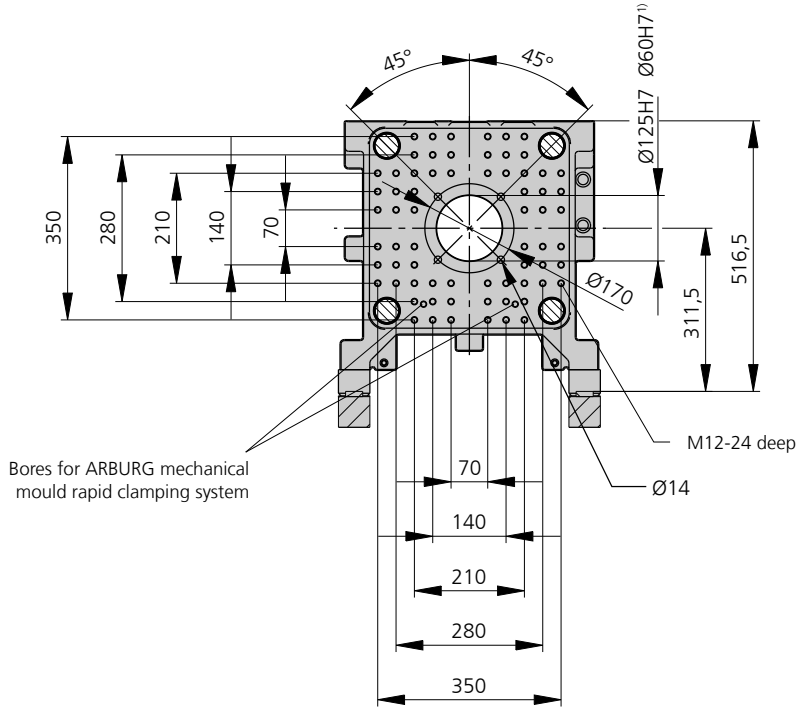
Robotic system mounting | C



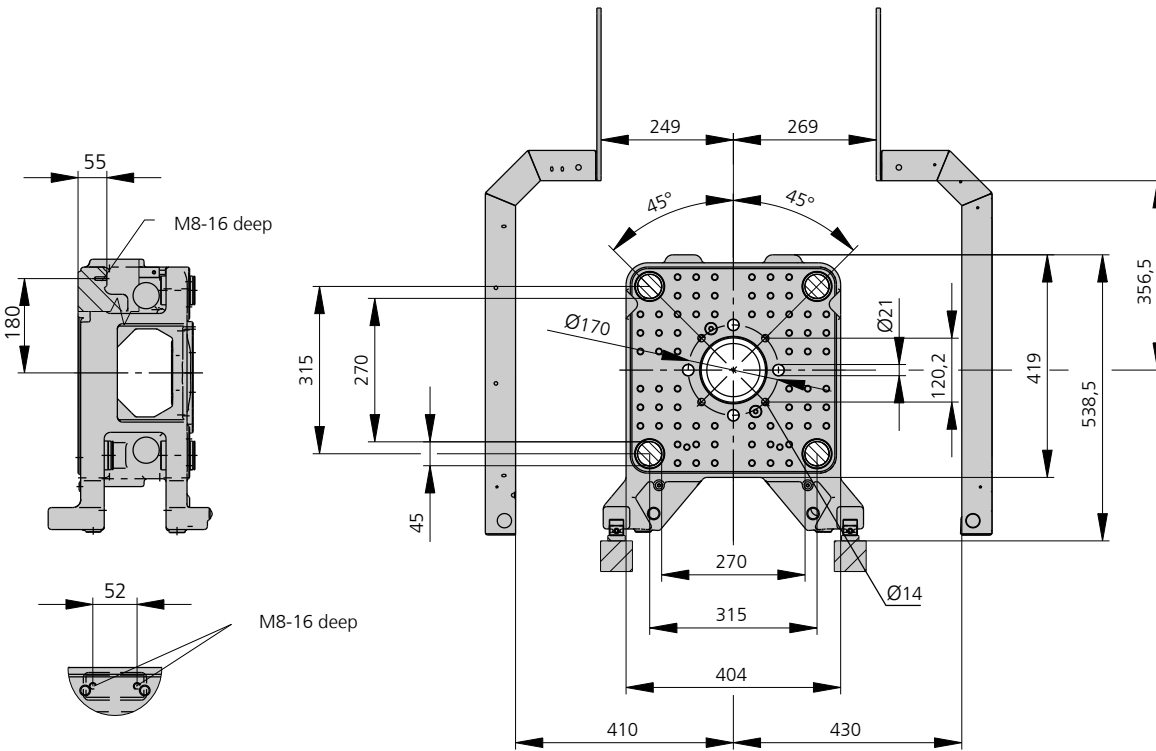
1) Optional with size 5 injection unit

MOULD INSTALLATION DIMENSIONS | 270 A

Fixed mould mounting platen | A



Moving mould mounting platen | B



1) Optional with size 5 injection unit

SHOT WEIGHTS | 270 A

Theoretical shot weights for the most important injection moulding materials

Injection units according to EUROMAP		5 ²⁾	70			100		
Screw diameter	mm	8	18	22	25	20	25	30
Polystyrene	max. g PS	2,3	21	31	40	29	45	65
Styrene heteropolymerizates	max. g SB	2,2	20	31	39	28	44	63
	max. g SAN, ABS ¹⁾	2,2	20	30	39	27	43	62
Cellulose acetate	max. g CA ¹⁾	2,6	24	35	45	32	50	73
Celluloseacetobutyrate	max. g CAB ¹⁾	2,4	22	33	42	30	47	68
Polymethyl methacrylate	max. g PMMA	2,4	22	32	42	30	46	67
Polyphenylene ether, mod.	max. g PPE	2,1	19	29	37	27	42	60
Polycarbonate	max. g PC	2,4	22	33	42	30	47	68
Polysulphone	max. g PSU	2,5	23	34	44	31	49	70
Polyamides	max. g PA 6.6 PA 6 ¹⁾	2,3	21	31	40	28	44	64
	max. g PA 6.10 PA 11 ¹⁾	2,2 2,1	19	29	37	26	41	60
Polyoximethylene (Polyacetal)	max. g POM	2,8	26	39	50	35	55	80
Polyethylene terephthalate	max. g PET	2,7	25	37	48	34	53	77
Polyethylene	max. g PE-LD	1,7	16	24	30	22	34	49
	max. g PE-HD	1,8	16	24	31	22	35	50
Polypropylene	max. g PP	1,8	17	25	32	23	36	51
Fluoropolymerides	max. g FEP, PFA, PCTFE ¹⁾	--	33	50	65	46	72	103
	max. g ETFE	--	29	44	57	40	63	91
Polyvinyl chloride	max. g PVC-U	--	25	38	49	35	54	78
	max. g PVC-P ¹⁾	--	23	35	45	32	50	72

1) average value

2) Normal working range for the size 5 injection unit is less than/greater than 50% of the specified values. PVC-P, PVC-U and fluoropolymers are not approved.

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